

Work Order ID 105248

105248

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Item ID: D2855 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Cap
 Start Date: 7/30/13 Start Qty: 38.00 *38* Cust Item ID:
 Required Date: 8/09/13 Req'd Qty: 38.00 *38* Customer:
 Reference:

Approvals: Process Plan: W Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2855	Rev B								

130 Small Fab 0.00
 130
 Small Fab Memo 0.00
 Small Fab PULL FROM W/O 102169
 38 X D2855P
 1- Drill as per Dwg D2855 using DT82352- Open holes to 19/64"3- Deburr
 pilot- 38 0 A 13.07.30
 Jm13-07-30

140 QC5- Inspect part completeness to step on W/O 0.00
 140
 QC Memo 0.00
 Quality Control
 38 13.08.01 DAS
 09

150 White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum 0.00
 150
 Powdercoat Memo 0.00
 Powder Coating START TIME: 2:15 OVEN TEMPERATURE:
 FINISH TIME: 2:45
 320215 38X4 m/f 13/08/07

m126125

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Item ID: D2855

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Cap

Start Date: 7/30/13

Start Qty: 38.00

38

Cust Item ID:

Required Date: 8/09/13

Req'd Qty: 38.00

38

Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept.
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

38 x 6 44 13/09/25

170

Small Fab

0.00

170

Small Fab

Memo

0.00

Small Fab

Install Inserts as per Dwg D2855

38 x 6 44 13/09/25

180

QC5- Inspect part completeness to step on W/O

0.00

180

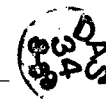
QC

Memo

0.00

Quality Control

38 x 6 13-9-25



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Item ID: D2855 Accept *N900040100* Setup Start *NS1*
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 Item Name: Cap
 Start Date: 7/30/13 Start Qty: 38.00 *38* Cust Item ID:
 Required Date: 8/09/13 Req'd Qty: 38.00 *38* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Identify as per dwg & Stock Location: <u>FP-001</u>	0.00							
190									
Packaging	Memo	0.00				<u>✓ 38</u>	<u>✓</u>	<u>HL 13/09/25</u>	
Packaging									
200	QC21- Final Inspection - Work Order Release	0.00							
200									
QC	Memo	0.00							
Quality Control									

HL 13/09/27

HL 13-09-24

Picklist Print

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Work Order ID: 105248

Parent Item: D2855

Parent Item Name: Cap

Start Date: 7/30/13

Required Date: 8/09/13

Start Qty: 38.00

Required Qty: 38.00

Comments: IPP: B00.06.22Added receiving step & removed P/O for powder coat EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
ALS7-1032-225 Insert		Purchased	No			100	Each	466.0000	2	76		13/09/25	

Location	Loc Qty	Loc Code
FG	100	
118520	100	
FP001	11	
118520	6	
122290	5	
ST281	355	
100896	135	
122333	220	

D2855-3
Cap

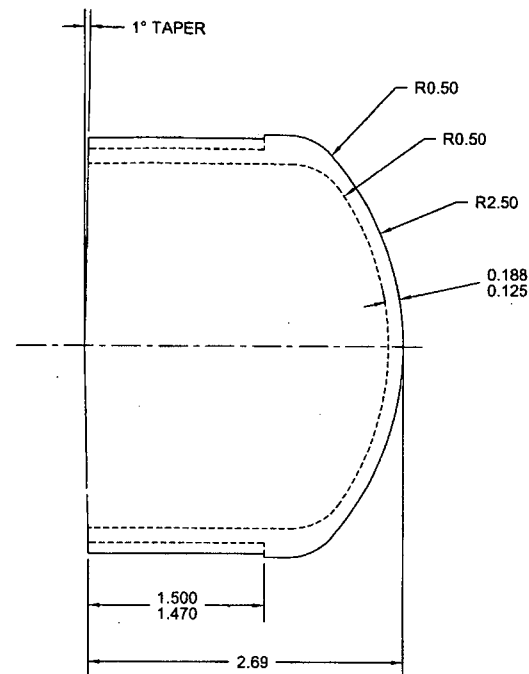
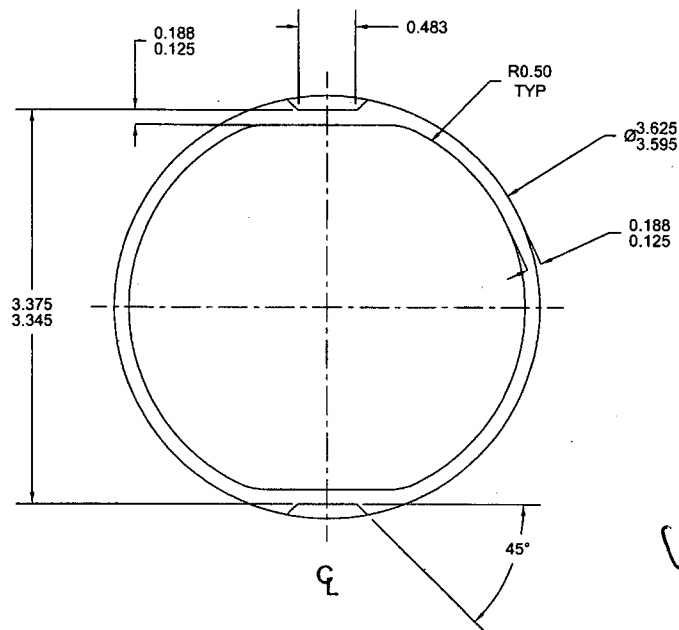
Manufactured No

Each 32.0000

38

Location	Loc Qty	Loc Code
FP001	32	
93817	7	
94723	25	

13-9-25



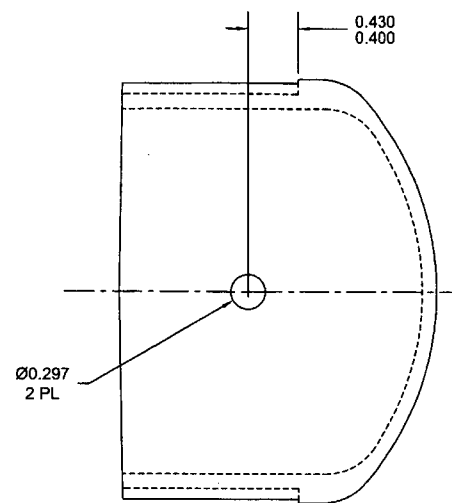
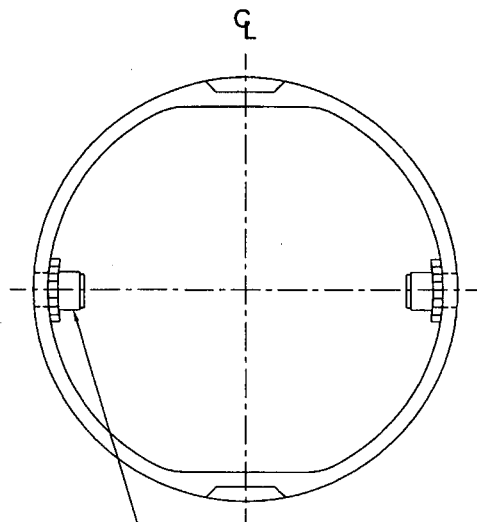
D2855C CASTING DETAIL B

RELEASED
09/17/15 MJD

NOTES:

- 1) MATERIAL: CASTING ALUMINUM ALLOY A356.2 (F)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.62 lbs

B	DRAWING UPDATED TO CURRENT STANDARDS. ADD D2855-3 & D2855C (ZN A4-1, A4-3)	RF	09.06.30
A	NEW ISSUE (WAS D2575 REV. E)	DS	96.12.12
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>RF</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D2855	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	CAP	NTS
DATE	09.06.30	<small>COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	



INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR
ALS7-1032-225, OR AKS4-1032-225) INSERT ON
INSIDE OF CAP (AFTER POWDER COAT)
2 PL

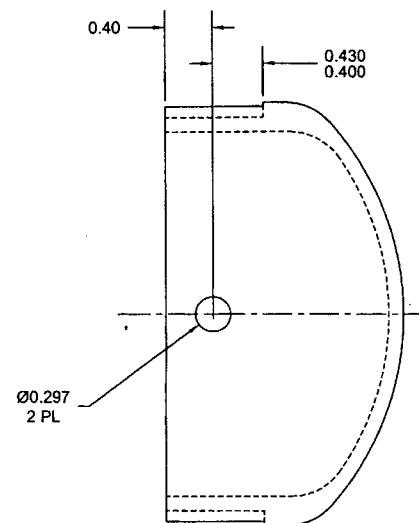
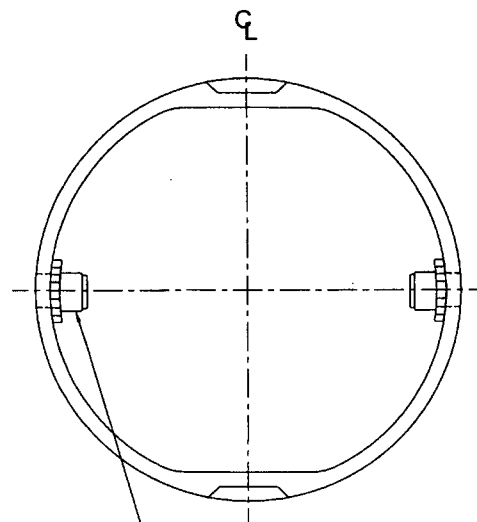
D2855 CAP
(MAKE FROM D2855C CASTING)

RELEASED
21/15/15


NOTES:

- 1) MATERIAL: MAKE FROM D2855C
- 2) FINISH: PODER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.63 lbs

DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	PH	DRAWING NO.	REV. B
MFG. APPR.	EP	D2855	SHEET 2 OF 3
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	CAP	NTS
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



INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR
ALS7-1032-225, OR AKS4-1032-225) INSERT ON
INSIDE OF CAP (AFTER POWDER COAT)
2 PL

D2855-3 CAP 
(MAKE FROM D2855C CASTING)

RELEASED
09/07/80

NOTES:

- 1) MATERIAL: MAKE FROM D2855C OR D2855
- 2) FINISH: PODER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.50 lbs

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D2855	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		CAP	NTS
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